Dart Aerospace Ltd. Tuesday, 1/9/2007 4:07:44 PM Date: SPLIT-2 Kim Johnston User: **Process Sheet** Drawing Name : CROSSBOLT SPACER Customer : CU-DAR001 Dart Helicopters Services : 30220 Job Number : 10993 Estimate Number : NIA : D2579 Part Number P.O. Number : D2579 REV D S.O. No. : with : 1/9/2007 **Drawing Number** This Issue : NC Project Number : N/A Prsht Rev. : MACHINED PARTS : NIH : D Type **Drawing Revision** First Issue : NA 460 : 29603 Material Previous Run 500 Um: : 1/22/2007 Qty: Due Date Written By Checked & Approved By : Est E Now turned on Cobra NG Comment Additional Product Job Number: Machine Or Operation: Description: Seq. #: M6061T6T0500W058 6031-T6 Tube .500 x.058W 1.0 0.3762 f(s)/Unit Total: 188.1075 f(s) Comment: Qty.: 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6 ) or 5052-H32 (WW-T-700/4) 103588 - 73 pcs DIP 07/03/08 Batch 103646→387pcs 0.500 Dia x 0.058 Wall HARDINGE CNC LATHE SMALL HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245 460 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 SECOND CHECK QC8 Comment: SECOND CHECK 460 5.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: L

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## Dart Aerospace Ltd

| W/O:      |       | WORK ORDER CHANGES     |          |       |      |                                     |                          |  |
|-----------|-------|------------------------|----------|-------|------|-------------------------------------|--------------------------|--|
| DATE STEP |       | PROCEDURE CHANGE       | Ву       | Date  | Qty  | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|           |       |                        |          |       |      |                                     |                          |  |
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|           |       |                        |          |       |      |                                     |                          |  |
| Part No   | : 111 | PAR #: Fault Category: | NCR: Yes | No DQ | A: 7 | Date: C                             | 7/03/13                  |  |

QA: N/C Closed: Date:

|           |                   |                             | WORK ORDER NON-CONFORMANCE (NCR) |  |  |  |  |  |  |  |  |
|-----------|-------------------|-----------------------------|----------------------------------|--|--|--|--|--|--|--|--|
| 155 may 2 | Description of NC | Corrective Action Section B |                                  |  | Verification   | A  |  |  |  |  |  |
| STEP      | Section A         | Initial<br>Chief Eng        | Action Description Chief Eng     | Sign &<br>Date   | Section C  | Approval<br>Chief Eng  | Approval<br>QC Inspector   |  |  |  |  |
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|           |                   |                             | Section A Initial Chief Eng      | Section A Initial Chief Eng Action Description Chief Eng | Section A Initial Chief Eng Chief Eng Chief Eng Date | Section A Initial Chief Eng Action Description Chief Eng Section C | Section A Initial Chief Eng Chief Eng Section C Chief Eng Section C Chief Eng Chief En |  |  |  |  |

NOTE: Date & initial all entries

Date:

Tuesday, 1/9/2007 4:07:45 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 30220

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



8071a31

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.03.13

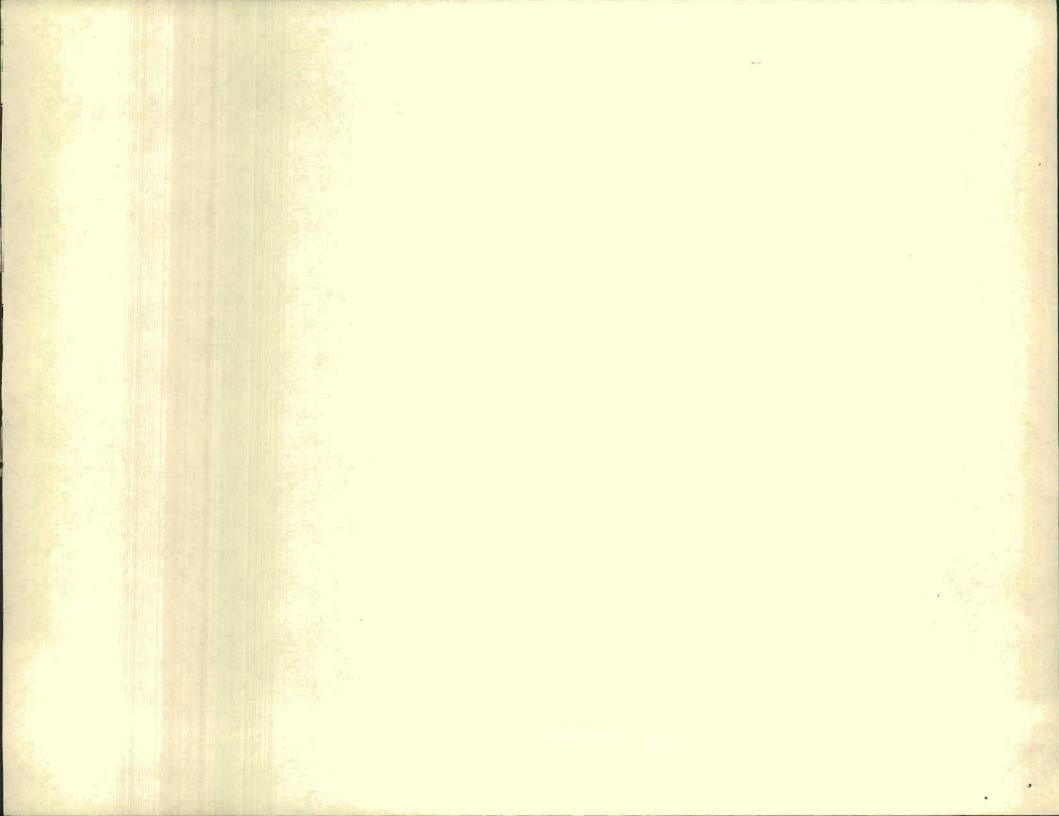
| Dart Ae | rospace L | _td               |                      |                              |             |              |       |                                     |                          |
|---------|-----------|-------------------|----------------------|------------------------------|-------------|--------------|-------|-------------------------------------|--------------------------|
| W/O:    | HEAL      |                   | WC                   | ORK ORDER CHANGES            |             |              |       |                                     |                          |
| DATE    | STEP      | PRO               | PROCEDURE CHANGE     | NGE                          | Ву          | Date         | Qty   | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|         |           |                   |                      |                              |             |              |       |                                     |                          |
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| Part No |           | PAR #:            | Fault Cate           | gory: NO                     | CR: Yes     | No <b>DQ</b> | A:    | Date:                               |                          |
|         |           |                   |                      |                              | QA: N       | /C Close     | d:    | _ Date: _                           |                          |
| NCR:    |           |                   | WORK ORDI            | ER NON-CONFORMANC            | E (NCR      | .)           |       |                                     | ##<br>2                  |
| DATE    | OTER      | Description of NC |                      | Corrective Action Section B  |             | Verific      | ation |                                     | Approval<br>QC Inspector |
| DATE    | STEP      | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign & Date | Secti        |       |                                     |                          |
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|         |           |                   |                      |                              |             |              |       |                                     |                          |
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NOTE: Date & initial all entries

| DART AEROSPACE LTD             | Work Order:  | 30220       |
|--------------------------------|--------------|-------------|
| Description: Cross Bolt Spacer | Part Number: | D2579       |
| Inspection Dwg: D2579 Rev: D   |              | Page 1 of 1 |

|                      | FIRS          | ST ARTICLE I        | and the second second |        |                         |       |          |
|----------------------|---------------|---------------------|-----------------------|--------|-------------------------|-------|----------|
|                      |               | X First Art         | icle                  | Prot   | otype                   |       |          |
| Drawing<br>Dimension | Tolerance     | Actual<br>Dimension | Accept                | Reject | Method of<br>Inspection | Con   | nments   |
| 4.070                | +/-0.030      | 4.08                | ~                     |        |                         |       |          |
| 0.058                | +/-0.010      | .060                |                       |        |                         |       |          |
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| Measured by:         |               | Audited by:         | C                     | D      | rototype Approva        | al    | N/A      |
|                      | 3C<br>1.03-07 | Date:               | 07/03/0               |        | Dat                     |       | 11071    |
| Rev Date             | Change        |                     |                       |        | Revis                   | ed by | Approved |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| Α   | 03.11.27 | New Issue | KJ/RF X    | -14      |
|     |          |           |            |          |

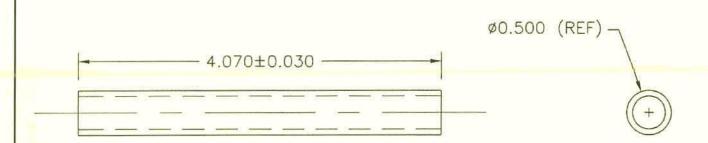






| DESIGN   | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|----------|----------|--|
| CHECKED  | APPROYED | DRAWING NO. REV. D D2579 SHEET 1 OF 1          |
| DATE     |          | TITLE SCALE                                    |
| 99.05.19 |          | CROSS BOLT SPACER 1:1                          |
| A        | 96.09.16 | NEW ISSUE                                      |
| В        | 96.12.05 | 0.065 WALL WAS 0.035 WALL                      |
| С        | 97.02.21 | 0.058 WALL WAS 0.065 WALL                      |
| D        | 99.05.19 | 4 070 LENGTH WAS 4 100 (TSR A1095)             |





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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.500 DIA × 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

